

S054503



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400224
Job Sheet 169859-A



Part No: RBT400224

Job Qty: 1 ea

Part Name: Clevis Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 1/30/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV 3 IPP REV:A 17.07.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	QC	1 pcs		1/30/18	0.00	0.00	QC6		DAS 21 SEP 21 2018
130	Packaging	1 pcs		1/30/18	0.00	0.00	Packaging3-1		21 SEP 21 2018
140	QC21-SA	1 Ea		1/30/18	0.00	0.00	QC21		DAS 21 SEP 21 2018

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 3/23/18 1:46 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
--------------	---------------	-----------------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					



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RBT400224
Job Sheet 169859



Part No: RBT400224

Job Qty: 2 ea

Part Name: Clevis Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/30/18

Created By: Diane Baker

Type: Stock

Description:

Customer: Bell Helicopter Miami Inc (CEDWA04)

PO Box 3689 Bristol, TN, 37625 USA ph:(954) 491-5071

Note: DWG REV 3 IPP REV:A 17.07.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		1/30/18	0.00	0.00	Purchasing		AT 1/30/21
110	Packaging	2 pcs		1/30/18	0.00	0.00	Packaging2		AT 1/30/21
120	QC	2 pcs		1/30/18	0.00	0.00	QC6		35
130	Packaging	2 pcs		1/30/18	0.00	0.00	Packaging3-1		9-05
140	QC21-SA	2 Ea		1/30/18	0.00	0.00	QC21		

Part Op 100 - ISSUE P/O: P0039711 SUPPLIER: METEC MANUFACTURE RBT400224 AS PER DWG C OF C
Descriptions: IS REQUIRED

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	RBT400224P	2	1	0	0

5053633

Part Specifications

Specifications could not be found.



Container No: S054503



Part: RBT400224

Job No: 169859 - A

Serial No/Batch: S053640

Revision: 3

Inspector:

Exp Date:

Instructions:

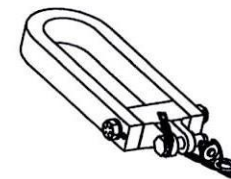
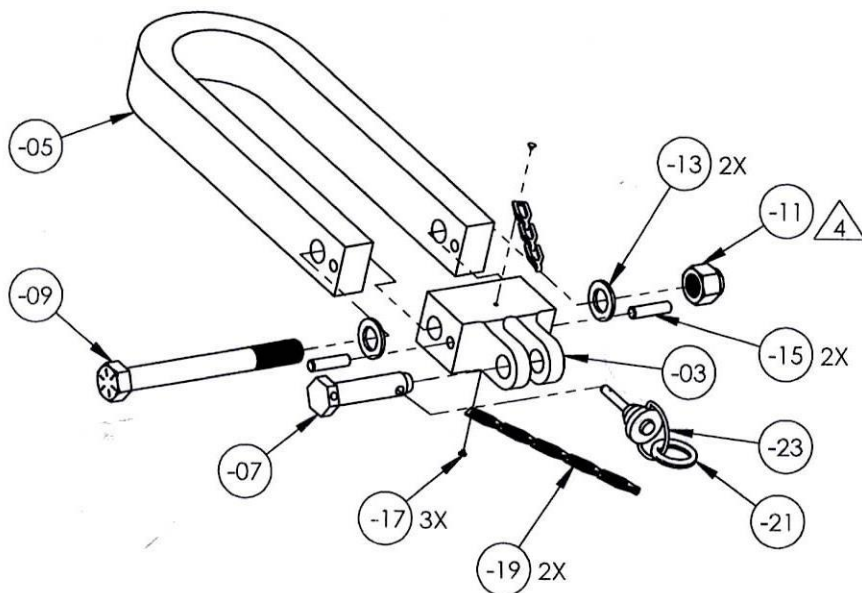
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Ex 1/2/18 9:52 AM dart.baker.diane

Date: 09/21/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 CORRECTED PROOF LOAD TESTING FROM 40000 LBS. TO 25000 lbs. AND CAPACITY TO 10000 lbs. PER INFORMATION FROM STAN.	7/20/2010	WP	RW
2		-07 CH'D FROM AN8-31A BACK TO NAS1308-38. -09 CH'D FROM AN8-46A TO NAS1308-64.	8/16/2010	WP	RW
3	15-0203	DELETED NOTE 3, ADDED NOTE 4.	8/13/2015	RJC	JAG



4wks

~~Part 1509 US~~

Metec -1760 coils (yes) x2

NOTE:

1. ORIGINAL T/N 204-011-178-001.
 2. PROOF LOAD TEST ASSEMBLY TO 25,000 lbs, WORK CAPACITY IS 10,000 lbs.
- △ TORQUE -11 NUT TO 440-550 in. lbs.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-03	1	CLEVIS	4140/4142		2
			-05	1	BELL	4140/4142		3
			-07	1	BOLT PIN	STEEL	NAS1308-38 MODIFIED	4
		B/O	-09	1	BOLT	STEEL	NAS1308-64	
		B/O	-11	1	LOCK NUT	STEEL	AN363-820	
		B/O	-13	2	WASHER	STEEL	AN960-816	
		B/O	-15	2	DOWEL PIN	STEEL	Ø1/4 X 1 (MCMaster-CARR #98381A542)	
		B/O	-17	3	#2 DRIVE SCREW	COATED STEEL	#.2 X 3/16 (MCMaster-CARR #91654A076)	
		B/O	-19	2	PLUMBER'S FLAT LINK CHAIN	STEEL	2/0 SIZE X 4-7/8 (MCMaster-CARR #3608T26)	
		B/O	-21	1	SPLIT RING	STEEL	Ø1 (MCMaster-CARR #90177A228)	
		B/O	-23	1	BALL LOCK PIN	S.S.	Ø3/16 X 3/4 (MCMaster-CARR #92384A013)	

DART
AEROSPACE

CLEVIS AND BELL

DWG NO.

RBT400224

REV
3

MATL

DRAWN BY: PERRITT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .005 FRACTIONS ± 1/8
XX ± .01 ANGLES ± .5°
X ± .1

HEAT
TREAT
FINISH

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SPEC
USED ON MODEL
BELL 204

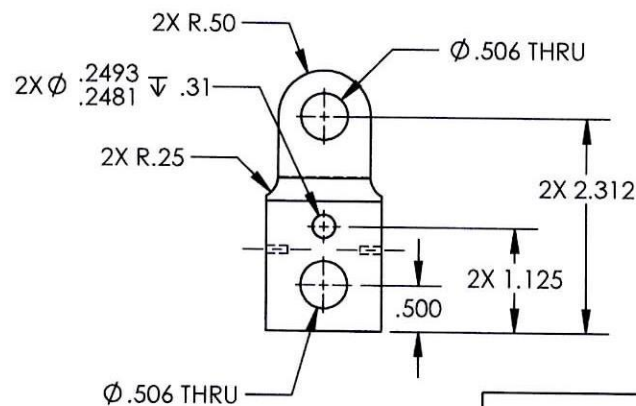
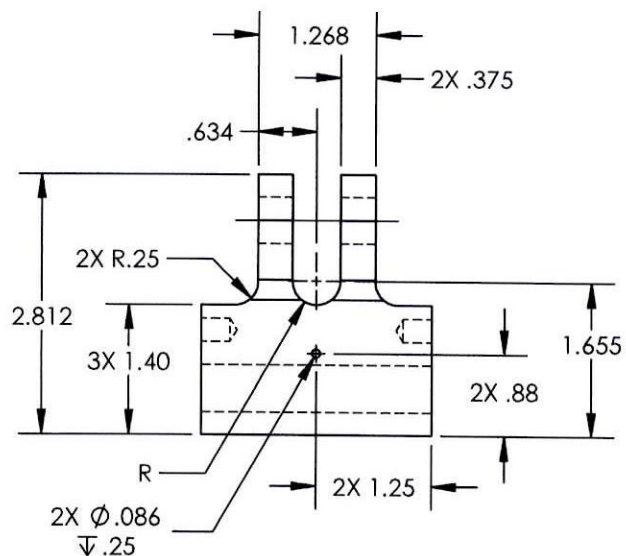
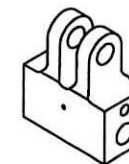
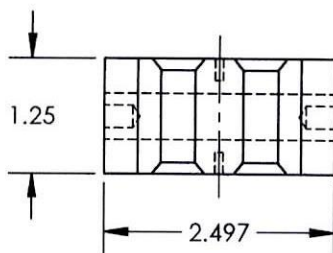
SCALE 1:1

DATE 6/16/2009

SHEET 1 OF 4

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



(-03)

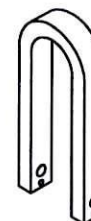
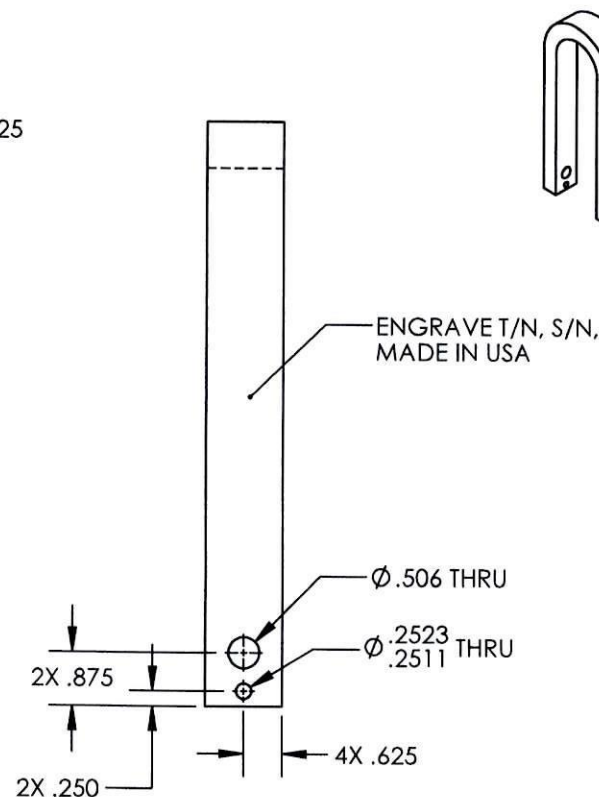
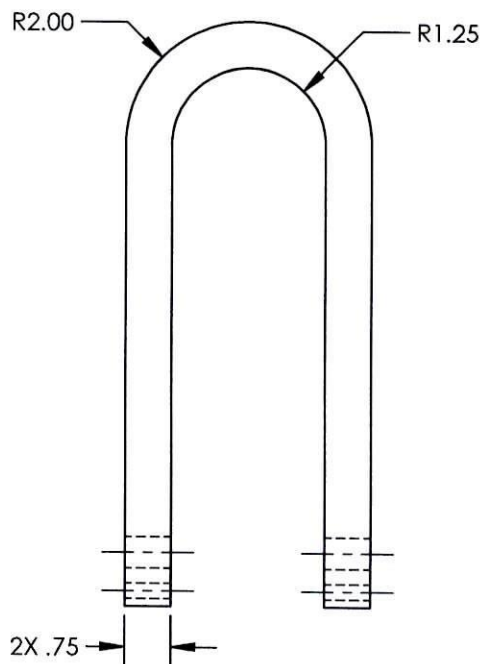
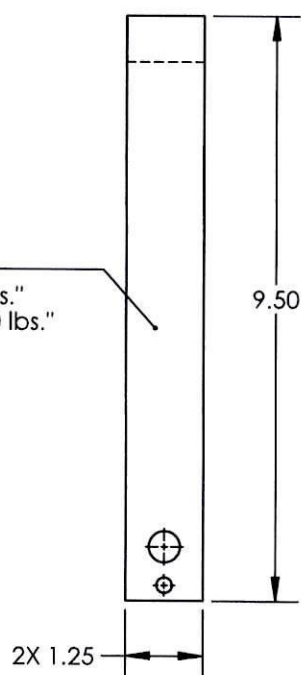
CLEVIS

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-03	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Well</i>
.XXX ± .005	HEAT TREAT RC 32-37
.XX ± .01	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204
SCALE 1:2	DATE 6/16/2009
SHEET 2 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-05 CORRECTED PROOF LOAD TESTING FROM 40000 LBS. TO 25000 lbs. AND CAPACITY TO 10000 lbs. PER INFORMATION FROM STAN.	7/20/2010	WP	RW

ENGRAVE 3/16 HT
"CAPACITY 10000 lbs."
PROOF LOAD 25000 lbs."



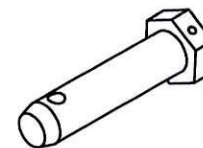
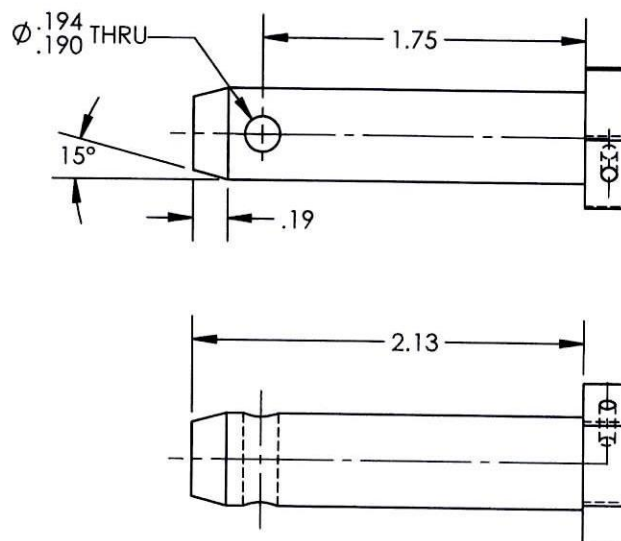
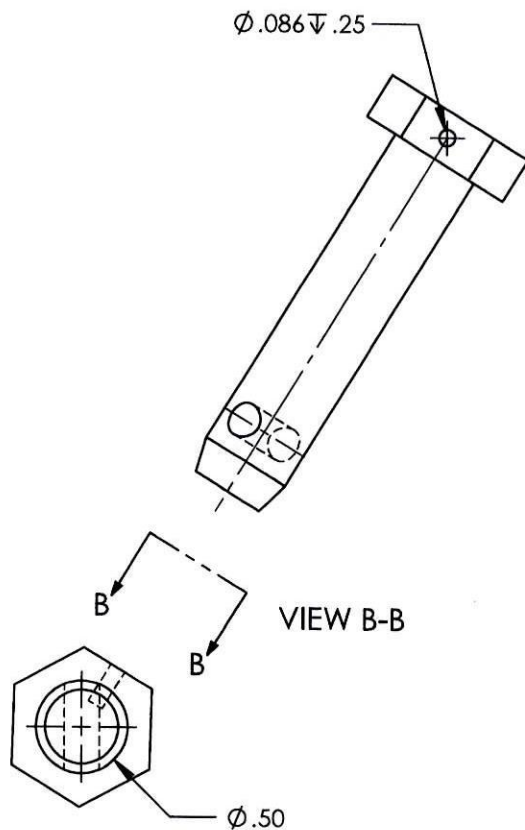
(-05)

BELL

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-05	REV 3
MAT'L 4140/4142	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT RC 32-37
.XX ± .01	TREAT CAD PLATE YELLOW
.X ± .1	FINISH QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC BELL 204
OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:3	DATE 6/16/2009
SHEET 3 OF 4	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-07 CH'D FROM AN8-31A BACK TO NAS1308-38.	8/16/2010	WP	RW



(-07)

BOLT PIN

DART AEROSPACE	
TITLE CLEVIS & BELL	
DWG NO. RBT400224-07	REV 3
MAT'L STEEL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC QQ-P-416, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL BELL 204
SCALE 1:1	DATE 6/16/2009 SHEET 4 OF 4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038711

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038711

PO Date: 1/2/18

Due Date: 1/30/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JAN 04 2018

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBT400224P			Clevis Assembly As per Dwg RBT400224 Rev.3	Firmed	1/30/18	2 pcs	0 pcs	2 pcs	\$1,760.00/pcs	\$3,520.00
										AT 1/8/18	38
										Grand Total:	\$3,520.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

[Handwritten signature]
C.L.
DOB



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity

Part Number

Part Name

P.O. Number

2 set

RBT400224P

Clevis Ass'y

38711

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, March 21, 2018



Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBT 400224

A

5053640

2018/09/21

Proof Load Capacity

25.000

LBS

Tested By:

ALAN PATRY

Technician

Approval:

Sylvie Boucher

Position:

QC 5 Small FAB / QA